

# SHEET METAL HEM AND HEM FORMING PROCESS

## Abstract

A reduced radius hem assembly and method for joining an inner panel and an outer panel together. The inner panel has an outwardly extending perimeter flange comprising an end surface, an inboard surface, and a beveled surface located between the end surface and the inboard surface. The outer panel has a peripheral edge comprising a bend portion, an intermediate portion, and an end portion. In the finished hem assembly, the intermediate portion is adjacent to the beveled surface of the perimeter flange and the end portion overlies a portion of the inboard surface of the perimeter flange. The method provides a reduced radius hem while allowing the peripheral edge of the outer panel to cover the marriage gap and minimizing the potential for interference between the inner panel and the outer panel in the hem assembly.